

Sub A²

- applying said foam from a discharge orifice of an applicator into a cassette open to the top, comprising said lower skin and said frame, said cassette then being joined to said upper skin,

wherein said applicator with said discharge orifice is moved two-dimensionally, one direction corresponding to said direction of transverse movement and the other direction corresponding to a direction of longitudinal movement.

3. The method as set forth in claim 2 wherein said movement corresponding to said longitudinal direction is a translatory movement in said longitudinal direction.

4. The method as set forth in claim 1 wherein said two-dimensional movement is programmable as a graphic line defined relative to said cassette, whereby also closing phases of said applicator are programmable.

5. The method as set forth in claim 1 wherein a second applicator having a second discharge orifice is provided.

6. The method as set forth in claim 5 wherein said second applicator is moved two-dimensionally substantially independent of said first applicator.

7. The method as set forth in claim 1 wherein said foam is a reactant mix reacting into a PUR/PIR foam.

8. The method as set forth in claim 1 wherein said sandwich element is a door element.

9. The method as set forth in claim 1 wherein said sandwich element comprises an opening of said foam layer and the portion corresponding to said opening is bypassed in application of said foam.

10. The method as set forth in claim 1 wherein said applicator(s) comprise(s) a self-cleaning recirculating mixer head.

11. The method as set forth in claim 1 wherein said cassette joined to said upper skin is introduced into a double-belt system.

12. The method as set forth in claim 1 wherein said cassette is singled prior to application of said foam.

13. The method as set forth in claim 1 wherein said cassettes prior to application of said foam are conveyed and heated in an inline oven with the aid of a conveyor means over an oven length so that said cassettes at the end of said oven length attain a processing temperature, said inline oven being divided into a plurality of oven zones passed through by said cassettes and each oven zone being operated, in the case of a temporary interruption

in operation and thus standstill of said conveyor means, at such an individually reduced temperature that said cassette waiting in said oven zone retains substantially a zone waiting temperature substantially corresponding to the temperature of a cassette in said oven zone under normal operating conditions, so that when normal operation is reinstated said cassettes are subjected to no substantial overheating above said prescribed process temperature.

14. The method as set forth in claim 1 wherein after application of said foam, latching means of said upper skin and of said frame of said cassette are caused to engage at least two opposite outer edges of said sandwich element formed by said skins and said frame with said filling so that said frame and said upper skin are joined, said latching means being powered into engagement by an automatic engaging device and said automatic engaging device in a relative inclined position of said upper skin and cassette first engaging said latching means on one of said two edges before then in maintaining this engagement translating said inclined position into a flat position, whereby in producing said flat position said latching means is caused to engage the other of said two sides.

15. A production system for implementing the method as set forth in claim 1.

FOOTNOTES